

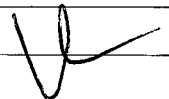
Work Order ID 144620

Thursday, April 28, 2016 10:05:43 AM

144620

Page 1

Item ID: D5291-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block Assembly
 Start Date: 5/5/2016 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5291	B								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks:1.520" long

50

0

DAS
14

9-89

16/05/29

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FB402 and DWG D5272

Dwg Rev B

Folio Rev AA

DEBURR

50

0

DAS
33
9-89

16/05/30

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Page 2

Hand Finishing

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Page 3

[illegible]

Work Order ID 144620

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Page 4

Item ID: D5291-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Radius Block Assembly**Start Date:** 5/5/2016 **Start Qty:** 50.00***50*****Cust Item ID:****Required Date:** 5/19/2016 **Req'd Qty:** 50.00***50*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

200

Identify as per dwg & Stock Location: St 16

0.00

200

Packaging

Memo

0.00

Packaging

SOX Das
6
9-89

JUN 15 2016

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS JUN 16 2016

2m 16/06/15

Picklist Print

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Page 1

Work Order ID: 144620

144620

Parent Item: D5291-041

D5291-041

Parent Item Name: Radius Block Assembly

Start Date: 5/5/2016

Required Date: 5/19/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A 15.07.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X00.125		Purchased	No				f	23.6700		7.526315			

M6061T6B0 500X00 125

6061-T6 Bar 0.500 x 0.125

Location

Loc Qty

Loc Code

MAT

23.67

m134058

23.67

Each

6,123.000

100

DAS
14
9-89

16/05/29

MS20426AD3-4

Purchased

No

MS20426AD3-4

RIVET

Location

Loc Qty

Loc Code

CCK004

4885

m134294

4885

GA

996

m131697

996

ST312

242

m131697

242

Each

257.0000

50

DAS
36
9-89

16/06/13

MS21076-4

Purchased

No

MS21076-4

Anchor Nut

Location

Loc Qty

Loc Code

over008

257

m133922

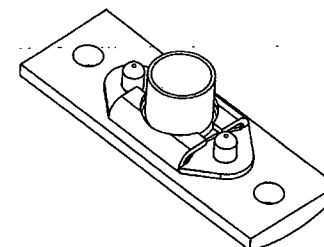
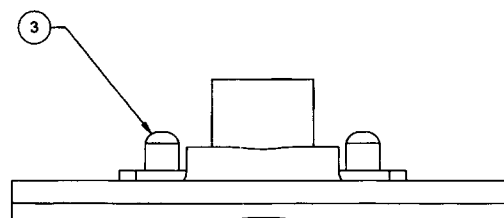
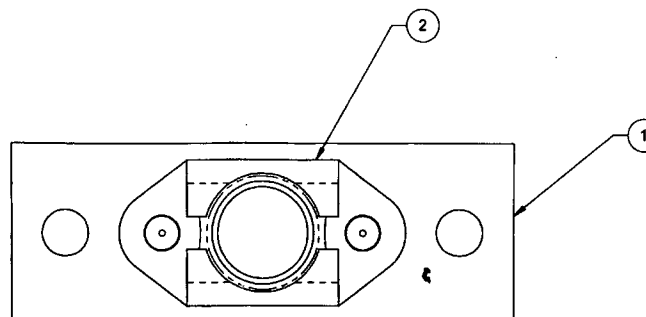
257

50

DAS
36
9-89

16/06/13

ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5291-041	ANCHOR NUT ASSEMBLY
1	1	D5291-1	RADIUS BLOCK
2	1	MS21076-4	ANCHOR NUT
3	2	MS20426AD3-4	RIVET, CSK



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WITHOUT NOTICE
WORK ORDER
NO. 144620 MJS

16-04-28

D5291-041 ANCHOR NUT ASSEMBLY

NOTES:

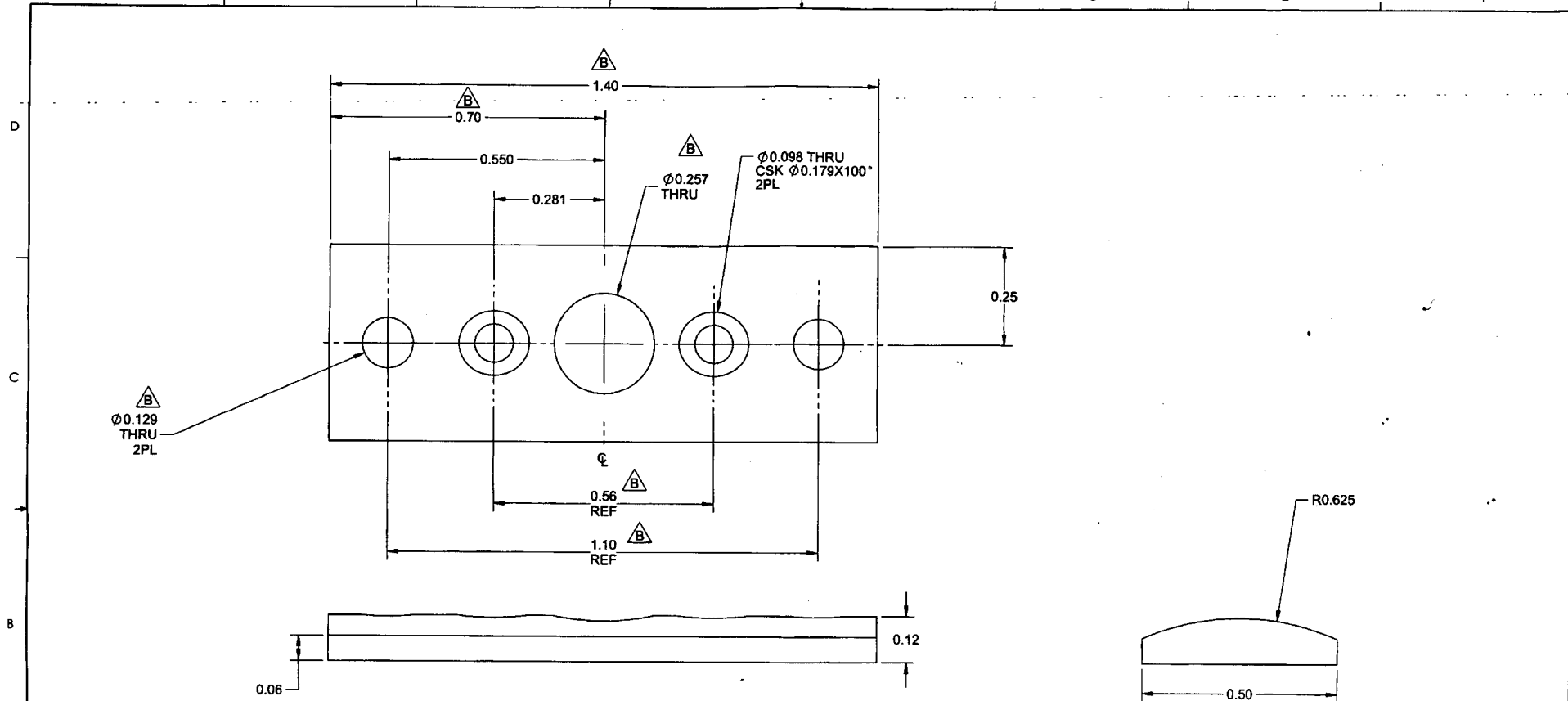
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5291-041" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED
2016-03-07
EN16-542

APPROVED

B	CHANGED RADIUS BLOCK LENGTH	CC	16.01.21
A	NEW ISSUE	CC	15.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5291	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ANCHOR NUT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D5291-1 RADIUS BLOCK

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINIUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR
AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005, SECTION 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2016-03-07
APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	AK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5291	SHEET 2 OF 2
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8 7 6 5 4 3 2 1